



# DECK TO HULL AND FLYBRIDGE BONDING

## PREPARATION OF GELCOAT

1. Abrade the proposed bonding area with 80-120 grit sandpaper to take off the gloss from the Gel coat and any wax that may be present, and eliminate dust with brush or vacuum cleaner.
2. Carefully Mask Tape the perimeter area to be prepared on the vessel.
3. Wipe bonding area with 100% Industrial Alcohol Cleaner or Methylated Spirits, (check small sample before application).

## PREPARATION OF FINISHED FIBREGLASS OR ALUMINIUM

1. Abrade the proposed bonding area with 100 grit sandpaper and eliminate dust or debris with a clean brush.
2. Carefully Mask Tape the perimeter area to be prepared on the vessel.
3. Wipe bonding area with 100% Industrial Alcohol Cleaner or Methylated Spirits, (check small sample before application).

## APPLICATION OF MSP 190, (original)

It is vital to check the accuracy of the fit, prior to applying the adhesive, so the parts do not have to be separated once brought together.

1. If a horizontal joint, place spacers in position, (thickness at least 3-4mm, approx. 50 Shore A hardness). These can be placed sideways into the adhesive, in order not to damage the continuity of the bead.
2. If a vertical joint, e.g. the shoebox fit Design, there is no need for spacers.

### Deck to Hull:

Apply MSP 190 around the entire periphery of the hull, (depending on the width of the bond face, 2 or 3 beads of MSP 190 should be applied).

1. The adhesive bead must be carried in a continual

motion around any cut outs or clearance holes, in order to maintain the integrity of the water tight joint.

2. Bring the two surfaces together within 30 minutes, and adjustment can occur after that time.

3. The weight of the deck should be enough to hold the two surfaces together use clamps or weights or clamps in areas where you knowingly need to compress the units together.

**Flybridge :** Apply MSP 190 in a triangular profile 10mm x 10mm, around the entire flybridge. Depending on expected size of load, an additional bead may be required.

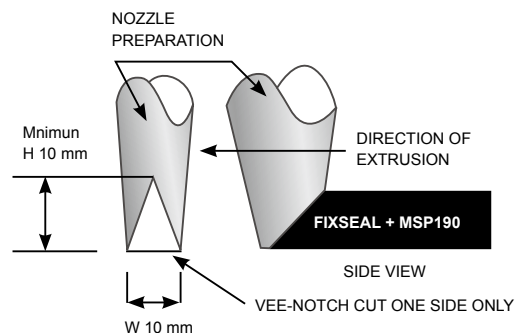
3. Assemble components within 20 minutes of applying adhesive.

4. Apply pressure with clamps or other fastening aids to compress the adhesive to the height of the spacers. Do not clamp too tight so as to displace the adhesive out.

5. Clamps and other fastening aids can be removed after 3-8 days. Service strength is attained after approximately 5-10 days. (Drying rate of 2-3 mm every 24 hours.) Full strength in 21 days.

6. Traces of uncured adhesive can be removed with methylated spirits or acetone. Traces of cured adhesive can be removed by mechanical removal.

The recommended profile should be



Example:

Load ultimate capacity = 1630 kg/m

Safe working load - Tension = 543 kg/m (FOS=3)

Shear = 652 kg/m (FOS=2.5)

